

Work Order ID 60891

Monday, July 26, 2010 1:53:43 PM



Page 1

Item ID:	D3213-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Assembly					
Start Date:	7/26/2010	Start Qty:	6.00			
Required Date:	8/2/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	<u>14</u>	Date:	<u>10-7-26</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3213	Rev A								

100
 Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab 1-Assemble as per Dwg D3213 Transfer drill hinge using DT8470 & DT9520
 Identify as D3213-041

8/10/08/10 (6)

110
 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control

8/10/08/10

(46)

120
 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00
 Powdercoat 1112588
 Powder Coating Memo 0.00
 START TIME: 1:45pm OVEN TEMPERATURE:
 FINISH TIME: 2:15pm 320°

⇒ 90

10/08/10

6 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3213-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Assembly

Start Date: 7/26/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 6.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>ml</u>	<u>10</u>	<u>08</u>	<u>11</u> (6)
140  Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D3213	0.00 0.00							<u>8/20/08/16</u> (6)
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>(6)</u>

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Accept

Revision ID:

Item Name: Door Assembly

Start Date: 7/26/2010 Start Qty: 6.00

Required Date: 8/2/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 51211

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

X6 BB 10/08/17

10/08/18

MF
10-8-17

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[illegible]

Required Date: 8/2/2010

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-17 17:27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-3  Hinge 15.0"		Manufactured	No			100	Each	15.0000	2	12		EP 10/08/10	
				<u>Location</u>									
				ST040				15					
				48513				5					
				48537				10					
D3213-1  Door Panel		Manufactured	No			100	Each	10.0000	1	6		EP 10/08/10	
				<u>Location</u>									
				ST232B				10					
				48497-1				10					
D3213-3  Door Panel		Manufactured	No			100	Each	13.0000	1	6		EP 10/08/10	
				<u>Location</u>									
				ST211				3					
				44233				3					
				ST232B				10					
				48498				10					

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60891

Parent Item: D3213-041

Parent Item Name: Door Assembly

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-6 Purchased No

100 Each

2,851.000

1

6



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST320

2851

113644

25

114905

1311

114988

1515

AN960JD6 NAS1149DN632 J Purchased No

140 Each

602.0000

1

6



Washer

Location

Loc Qty

Loc Code

ST347

602

104537

602

D2137 Manufactured No

140 Each

14.0000

1

6



Decal - No Step

Location

Loc Qty

Loc Code

ST006

14

59395

14

D2419 Manufactured No

140 Each

2.0000

1

6



Handle

Location

Loc Qty

Loc Code

ST014

2

59638

2

EP 5/0/08/16

EP 5/0/08/16

EP 5/0/08/16

EP 5/0/08/16

2
B61223 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3213-041



Parent Item Name: Door Assembly

Start Date: 7/26/2010

Required Date: 8/2/2010

Start Qty: 6.00

Required Qty: 6.00

D2462
Seal

Manufactured No

140 f

620.0007 2.4

14.4



Ep 50/08/16

Location

Loc Qty

Loc Code

ST404

620.0007

48530

620.0007

14.4

D2728-1
Dart Logo label
MS20470AD4-4
Rivet, Universal Head

Manufactured No

140 Each

0.0000 0

0



Ep 50/08/16

140 Each

2,089.000 24

144



Ep 50/08/10

Location

Loc Qty

Loc Code

ST319

1940

112314

30

113368

92

115156

1818

ST321

149

114761

149

144

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Shop Packet Print

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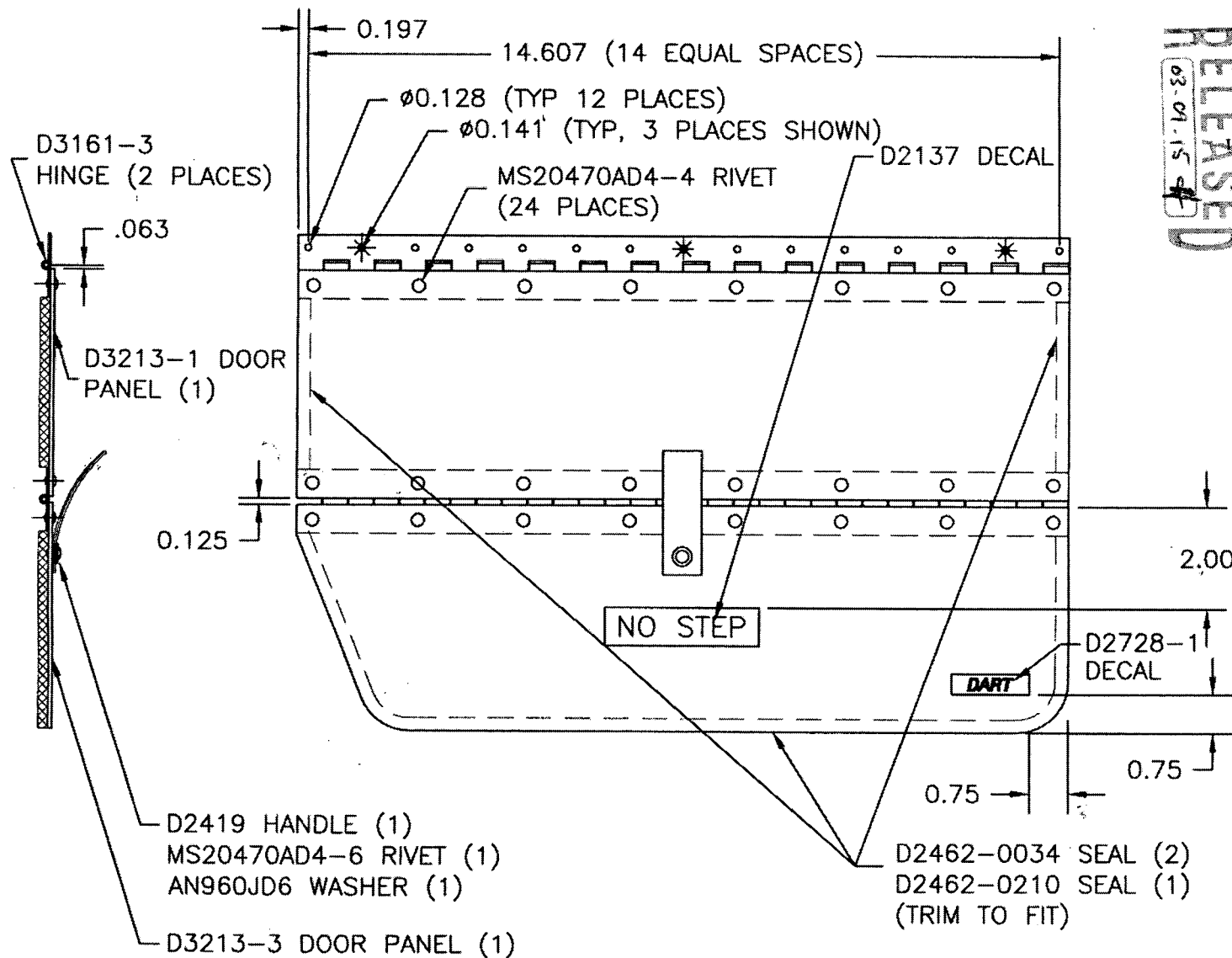
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RELEASED
03-01-15

SHOP COPY
DART AEROSPACE LTD
SUBJ: WORK
NO. 2510-7-24



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE 03.09.03	03.09.03	TITLE DOOR ASSEMBLY
A	NEW ISSUE	REV. A 1 OF 2 SCALE 1:3

D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

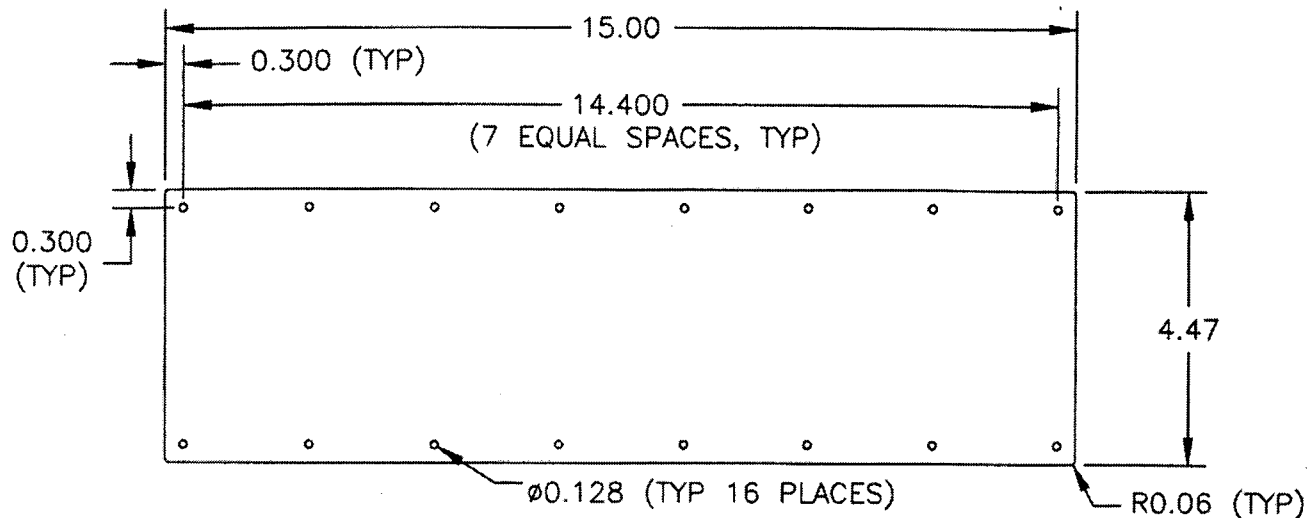
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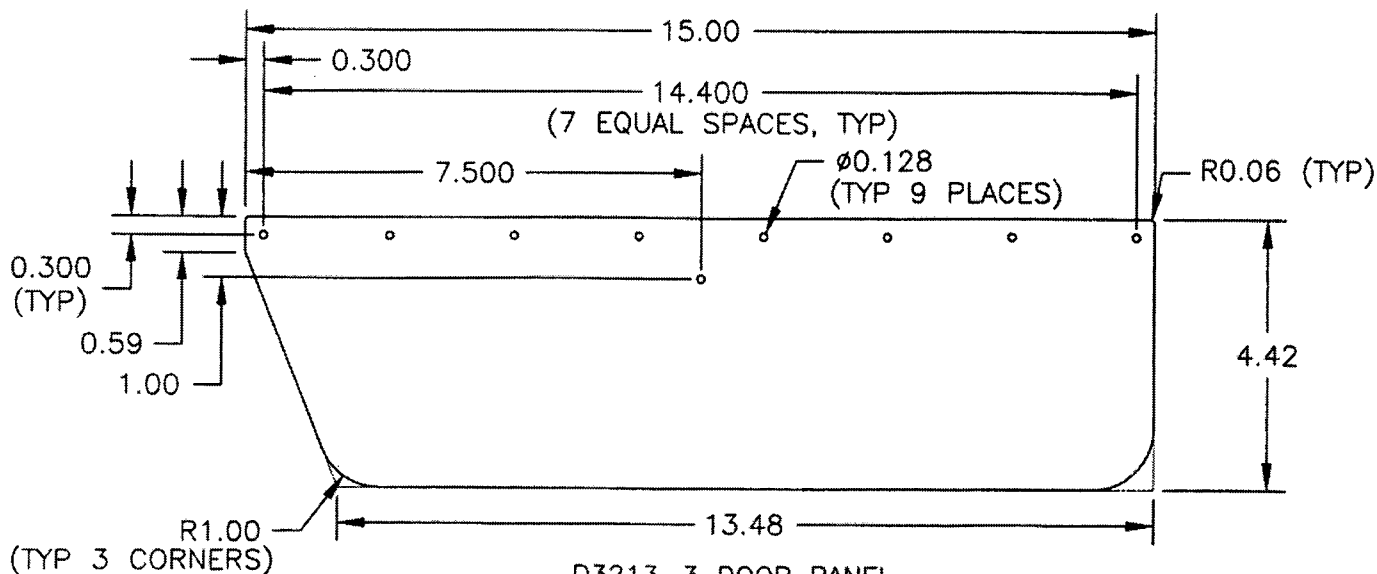


w/o 6089

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15

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Dart Aerospace Ltd

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